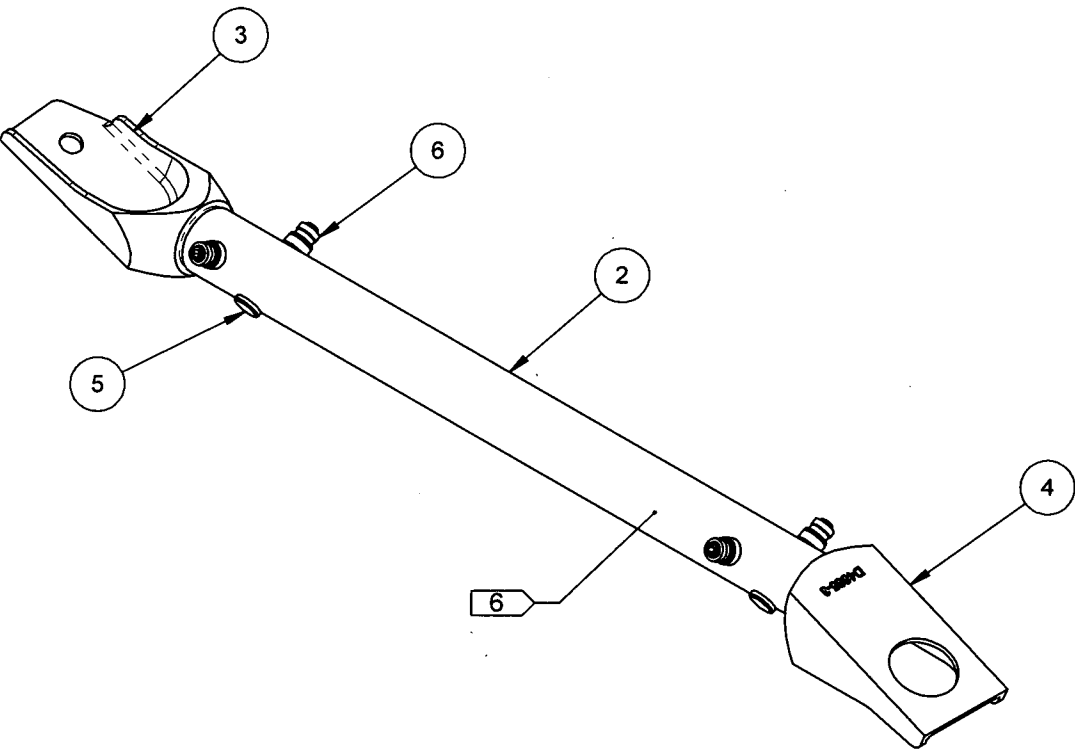


ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D4881-041	AFT LEG ASSEMBLY, LH
2	1	D4881-1	STRUT
3	1	D4885-1	END FITTING
4	1	D4885-3	END FITTING
5	4	HL32PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR

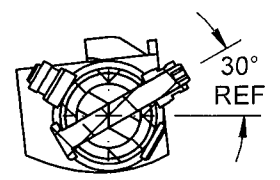
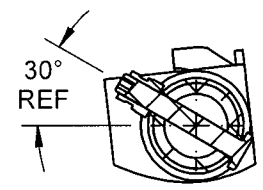
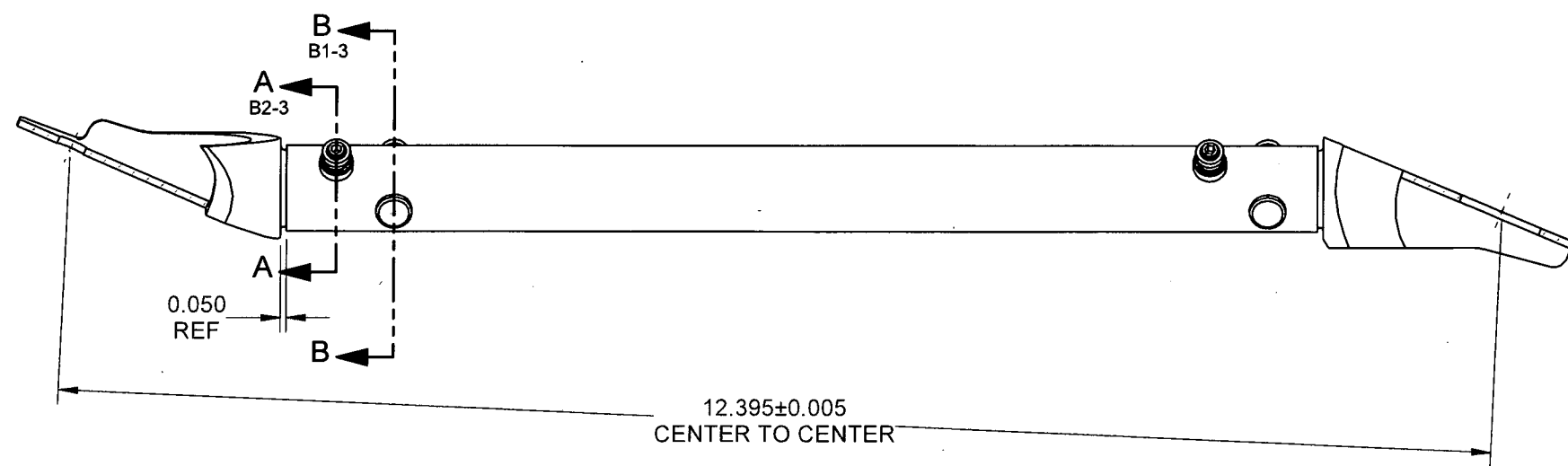
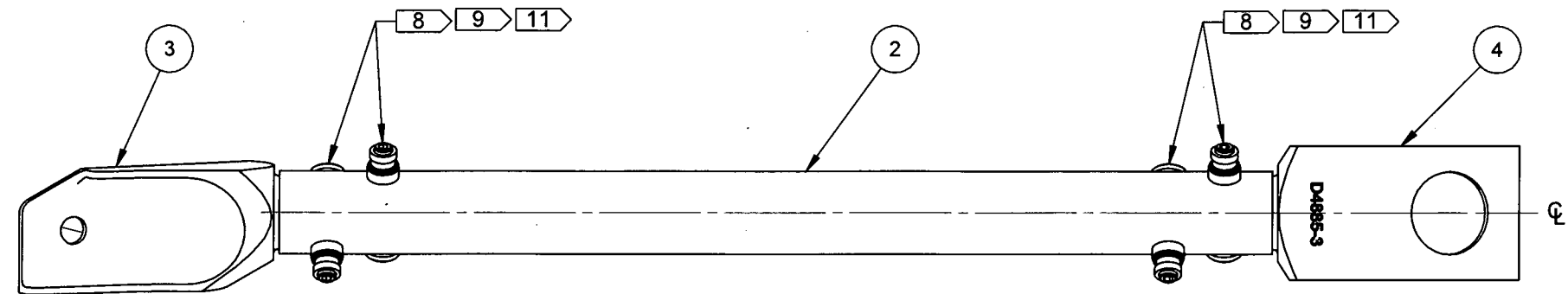


D4881-041 AFT LEG ASSEMBLY, LH
(EQUIVALENT TO BELL P/N 206-062-103-017)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.8
 - 7) WEIGHT: 0.77 lbs
 - 8) ALIGN PILOT HOLES IN D4881-1 WITH PILOT HOLES IN D4885-1 & D4885-3.
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.
REAM EACH HOLE USING P/N 31-219 (Ø0.1610) REAMER, USING DART TOOL SETUP DT9973
 - 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA OR MAGNOBOND 6398 ADHESIVE WHILE STILL WET
 - 10) ASSEMBLE PER DART TOOL DT9973
 - 11) INSTALL HL32PB5-12 HI-LOK IN ORIENTATION SHOWN

RELEASED
2014 -07- 07

C	HL32PB5-12 WAS HL20PB5-12 (ZN D4-1, D4-3); REVISE NOTE 6) (ZN A8-5)	RF	14.06.24
B	REVISE NOTES 6), 7) & 9) (ZN A8-1, A8-3); ADDED BELL P/N; REVISE SECTIONS A-A, B-B, C-C, D-D (ZN B1-2, B2-2, B1-4, B2-4)	RF	14.04.08
A	NEW ISSUE	RF	13.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D4881	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
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SECTION A-A C7-3
2 PL

SECTION B-B C7-3
2 PL

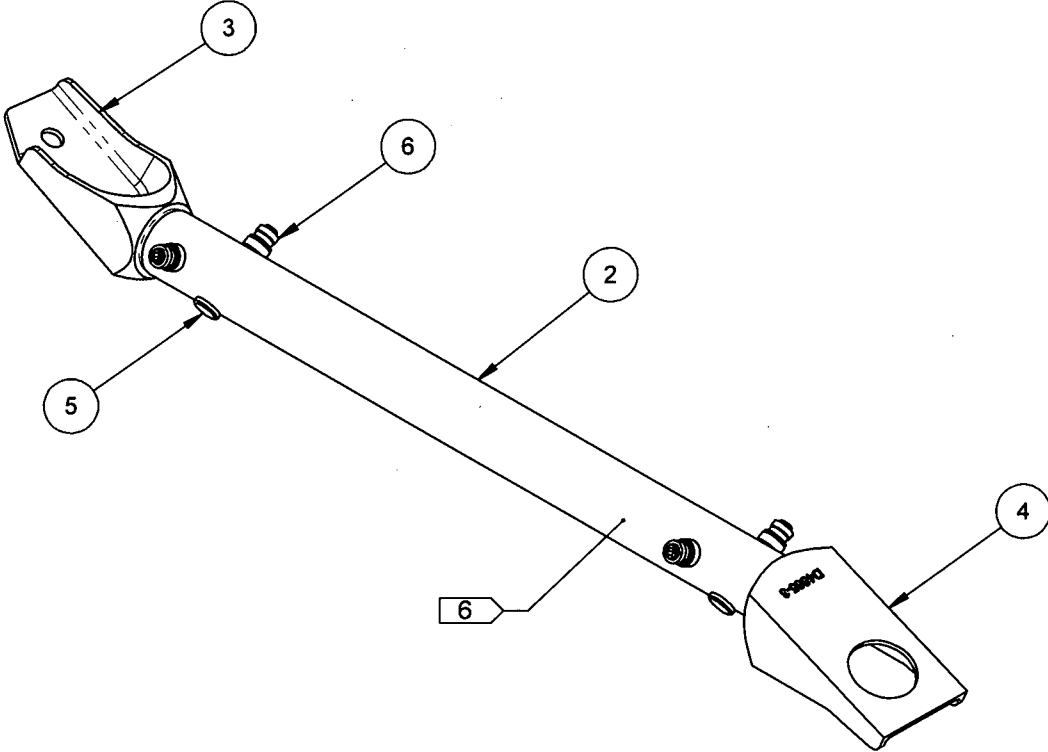
D4881-041 AFT LEG ASSEMBLY, LH
AUXILIARY VIEW

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2014 -07- 07
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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO. D4881	REV. C
MFG. APPR.	JLM		SHEET 2 OF 5
APPROVED	HS	TITLE LEG ASSEMBLY	SCALE NTS
DE APPR.	DS	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
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ITEM	QTY. -042	P/N	DESCRIPTION
1	X	D4881-042	AFT LEG ASSEMBLY, RH
2	1	D4881-1	STRUT
3	1	D4885-2	END FITTING
4	1	D4885-3	END FITTING
5	4	HL32PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR

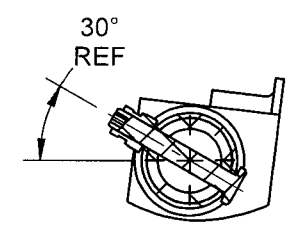
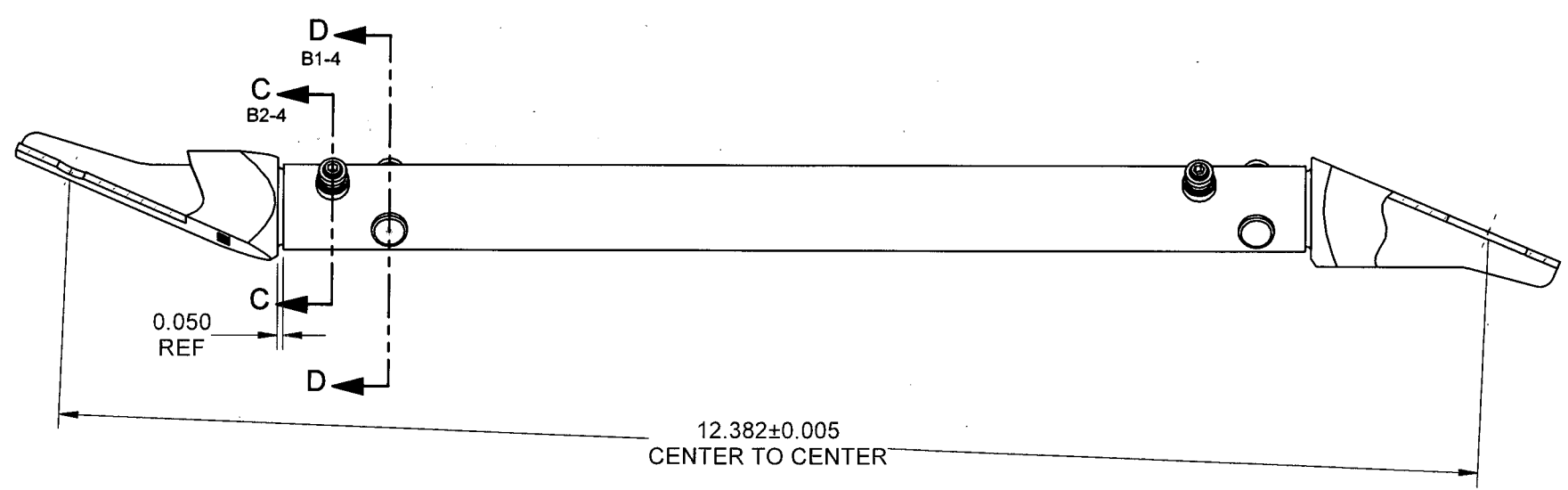
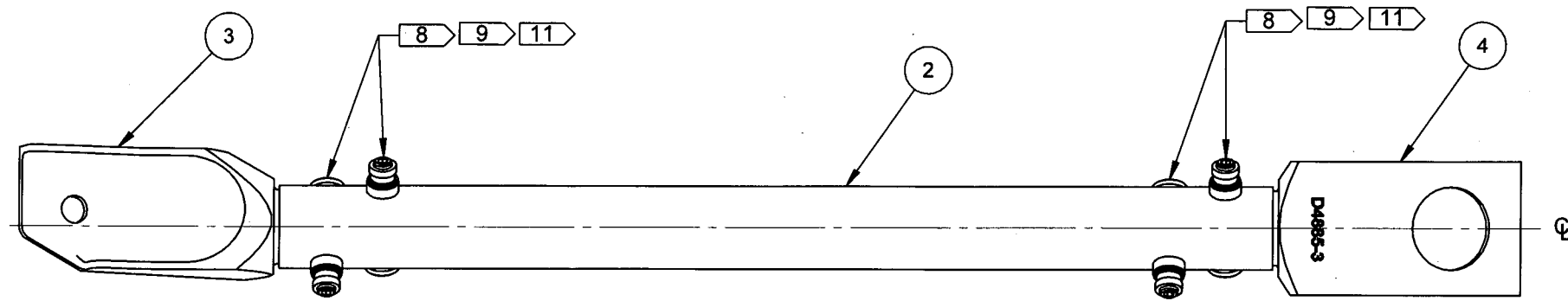


D4881-042 AFT LEG ASSEMBLY, RH
(EQUIVALENT TO BELL P/N 206-062-103-018)

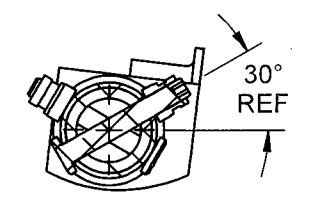
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.8
 - 7) WEIGHT: 0.78 lbs
 - 8) ALIGN PILOT HOLES IN D4881-1 WITH PILOT HOLES IN D4885-2 & D4885-3.
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.
REAM EACH HOLE USING P/N 31-219 (Ø0.1610) REAMER, USING DART TOOL SETUP DT9974
 - 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA OR MAGNOBOND 6398 ADHESIVE WHILE STILL WET
 - 10) ASSEMBLE PER DART TOOL DT9974
 - 11) INSTALL HL32PB5-12 HI-LOK IN ORIENTATION SHOWN

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2014-07-07
MP

APPROVED	DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	RF		
	CHECKED	VS	DRAWING NO. D4881	REV. C
	MFG. APPR.	JLM	SHEET 3 OF 5	
	APPROVED	HS	TITLE LEG ASSEMBLY	SCALE NTS
	DE APPR.	DS	COPYRIGHT © 2013 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DATE		14.06.24		



SECTION C-C C7-4
2 PL



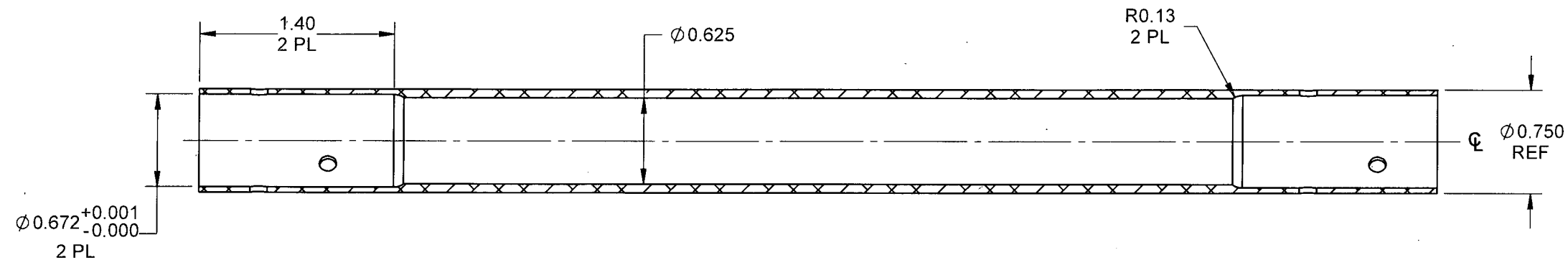
SECTION D-D C7-4
2 PL

RELEASED
2014 -07- 07
MP

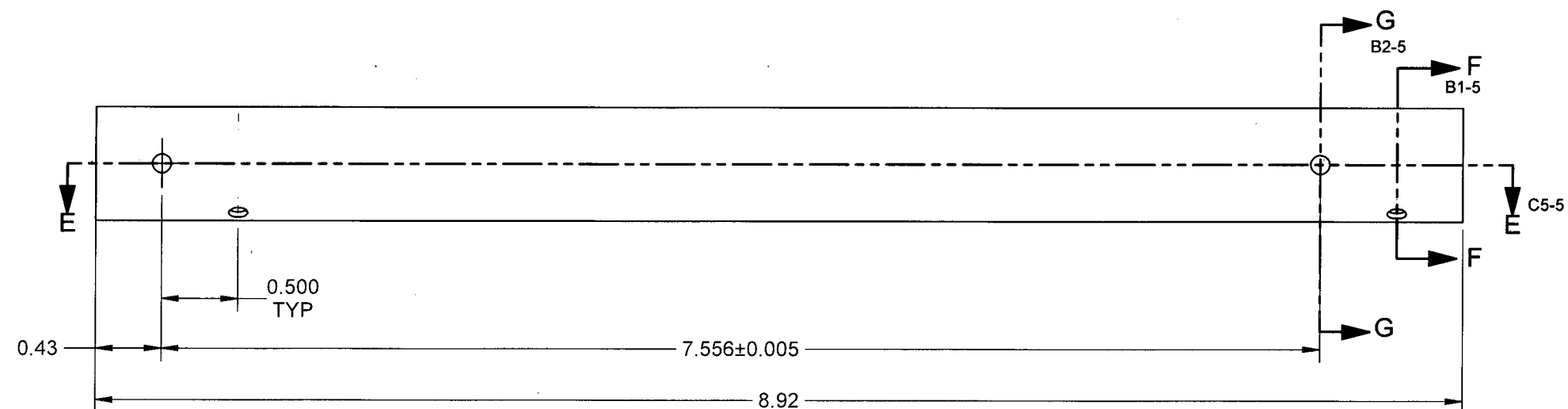
D4881-042 AFT LEG ASSEMBLY, RH
AUXILIARY VIEW

APPROVED

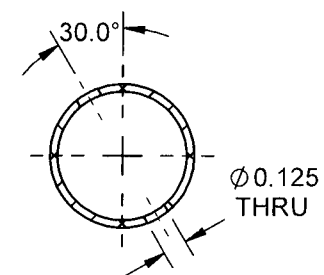
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO. D4881	REV. C
MFG. APPR.	JLM	SHEET 4 OF 5	
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
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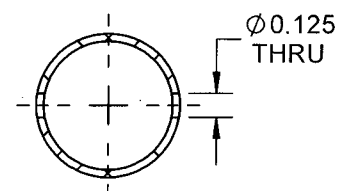
SECTION E-E B3-5



D4881-1 STRUT



SECTION F-F C3-5
2 PL



SECTION G-G C3-5
2 PL

RELEASED
2014-07-07

NOTES:

- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.6
- 7) WEIGHT: 0.30 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

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DRAWN	RF		
CHECKED	VS	DRAWING NO. D4881	REV. C
MFG. APPR.	JLM		SHEET 5 OF 5
APPROVED	HS	TITLE LEG ASSEMBLY	SCALE
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